Work Order ID 53670

November 12, 2009 8:11:37 AM

PRELIMINARY ISSUE

Item ID: D4013-5
Revision ID: A-PRELIM
Item Name: Cup

Accept

Setup Start
Stop

Start Date: 11/12/09 **Start Qty:** 6.00
Required Date: 11/16/09 **Req'd Qty:** 6.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4013	A-PRELIM

100
Doosan
Doosan Lathe

0.00

Memo
turn as per Dwg
Dwg Rev: A-Prelim

0.00

Deburr

6 0

110
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

6 0

120
QC
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

09.11.13

6 0

Work Order ID 53670

November 12, 2009 8:11:38 AM

Item ID: D4013-5
Revision ID: A-PRELIM
Item Name: Cup

Start Date: 11/12/09 **Start Qty:** 6.00
Required Date: 11/16/09 **Req'd Qty:** 6.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WE	0.00				SP	09	11	13 (GK)
Packaging	**Memo**	0.00							
Packaging	ENG								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

ADO324NOV

POSITIVE RECALL
EFFECTIVE 9-11-12 AUTH U
RELEASED _____ DATE _____

U 09-11-19

Picklist Print

November 12, 2009 8:11:37 AM

Work Order ID: 53670

Parent Item: D4013-5

Parent Item Name: Cup

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM

Start Date: 11/12/09 **Required Date:** 11/16/09

Start Qty: 6.00 **Required Qty:** 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.00 304 ROUND BAR 1.00		Purchased	No			100	f	0.0000	0.9474			

M109541 SA 07/11/13

DART AEROSPACE LTD	Work Order:	53670
Description: C-A	Part Number:	4013-5
Inspection Dwg: 4013-5 Rev: Prelim		Page 1 of 1

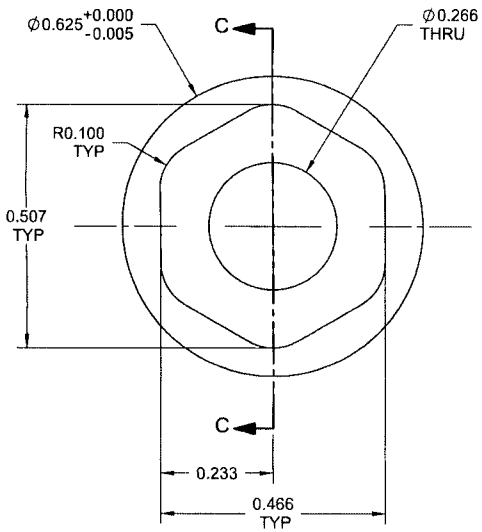
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

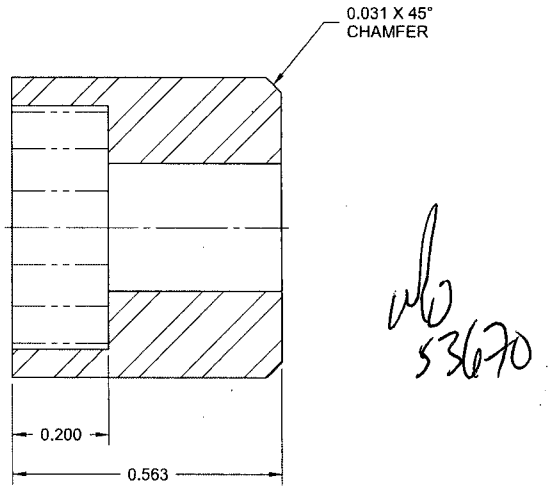
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.625	+.000 -.003	Ø.624	✓			
Ø.266	+.006 -.001	Ø.2685	✓			
.507	±.010	.507	✓			
.466	±.010	.467	✓			
.200	±.010	.201	✓			
.563	±.010	.561	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/11/13	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4013-5 CUP B2-5



SECTION C-C D6-5

53670

PRELIMINARY ISSUE

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC. M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs EACH

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4013 REV. P1
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.11.11	

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